

Date: Thursday, 13/11/2008 1:09:28 PM  
 User: Julie Dawson

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	DOUBLER		
Job Number	43430D			Part Number	D32203		
Estimate Number	10296			Drawing Number	D3220 REV A1		
P.O. Number				Project Number	N/A		
This Issue	13/11/2008	S.O. No.		Drawing Revision	A1		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	05/12/2008	Qty:	4
Previous Run	40462			Um:	Each		
Written By							
Checked & Approved By	JUL 08.11.14						
Comment	Est Rev: A New Issue 05-11-06 JLM Est: B 06.11.15 waterjet EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
		 <b>Comment:</b> Qty.: 0.6233 sf(s)/Unit Total : 2.4931 sf(s) <b>Material:</b> 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) <b>Identify for D3220-3</b> <b>Batch:</b> 107711 <b>HB 8-11-21</b>
2.0	WATER JET	<b>A1</b>  <b>Comment:</b> FLOW WATER JET <b>HB 8-11-21</b>
3.0	QC2	 <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <b>HB 8-11-21</b>
4.0	QC8	 <b>Comment:</b> SECOND CHECK <b>HB 8-11-21</b>
5.0	HAND FINISHING1	 <b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <b>M. J. 08/11/2008</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 1:09:28 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43430D

Part Number: D32203

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 17234



8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

-Job Completion



MF-08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43430D
Description: Doubler	Part Number:	D3220-3
Inspection Dwg: D3220	Rev: A1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>BB</u>	Audited by: <u>CD</u>	Prototype Approval: N/A
Date: 8-11-21	Date: 08/11/21	Date: N/A

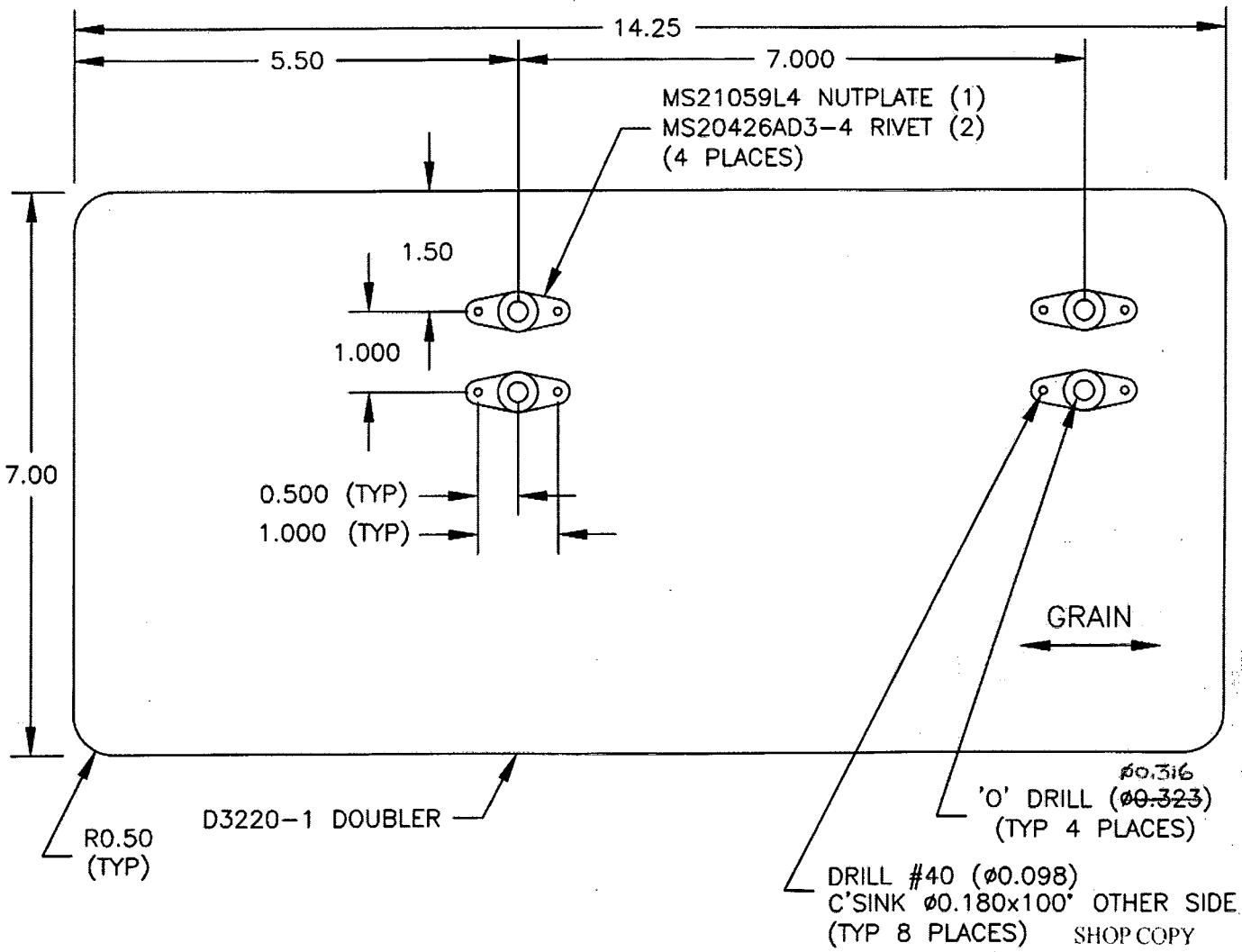
Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue	P/O D412-698-013	KJ/RF <i>[Signature]</i> <i>[Signature]</i>

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3220 REV. A SHEET 1 OF 2
DATE		TITLE DOUBLER SCALE 1:2
03.10.16		
A	03.10.16	NEW ISSUE
A1	CP 03.11.13	CORRECTED DIM.

**RELEASED**

03.11.14



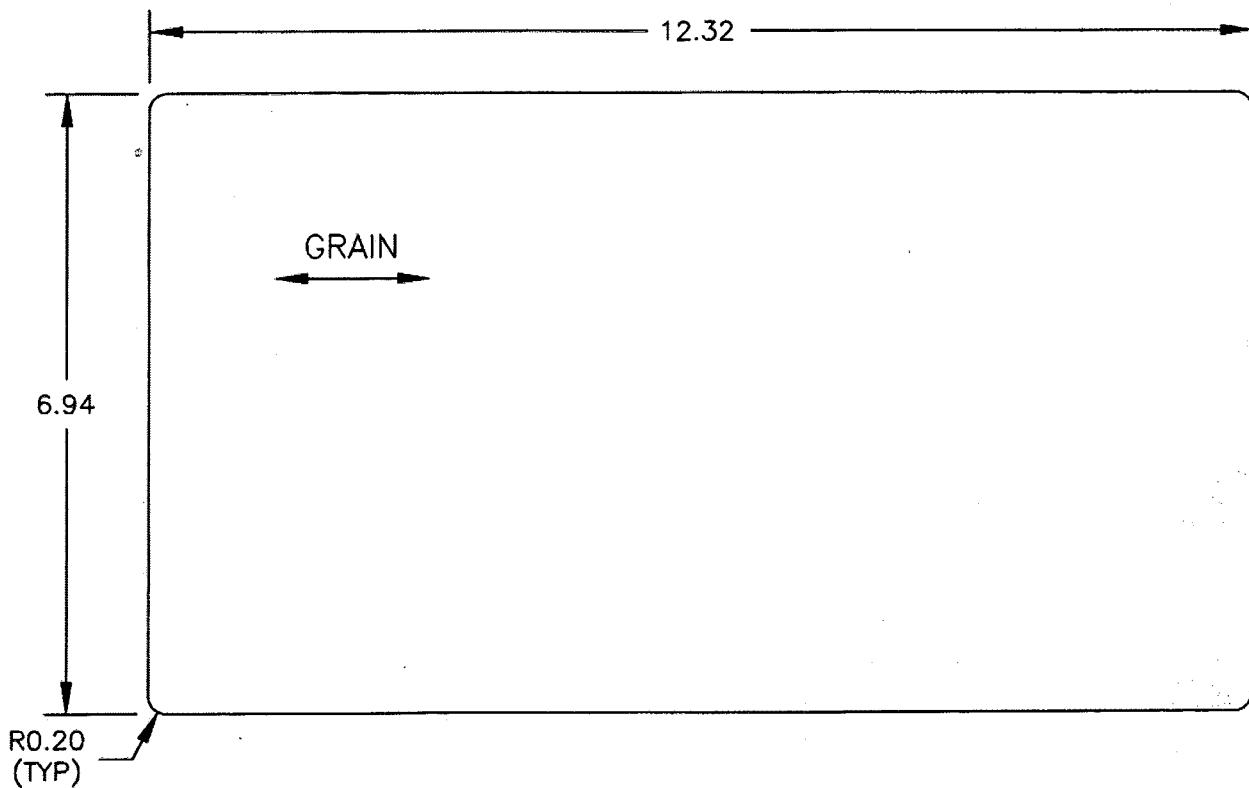
**D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)** RETURN TO  
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK ENGINEERING  
(REF DART SPEC. M2024T3S.090) UNCONTROLLED COPY  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 SUBJECT TO AMENDMENT  
3) BREAK ALL SHARP EDGES 0.005 TO 0.010 WITHOUT NOTICE  
4) ALL DIMENSIONS ARE IN INCHES WORK ORDER  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED. NO. 439301

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**DART**

DESIGN <i>HP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HP</i>	APPROVED <i>HP</i>	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16	TITLE DOUBLER		SCALE 1:2

**RELEASED**  
03.11.14**D3220-3 DOUBLER**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 43430D

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